

Work Order ID 53430

November 4, 2009 10:05:23 AM

Page 1

Item ID: D3136-043

Accept

Setup Start

Revision ID: E

Stop

Item Name: Window Assembly

Start Date: 11/04/09 Start Qty: 1.00

Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3136

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

B 9-11-4

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-11-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) Sorlulob4

(40)

Work Order ID 53430

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Page 2

Item ID: D3136-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Window Assembly

Start Date: 11/04/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo 1-Thermoform as per Dwg D3136 and Folio FTA002□Dwg Rev. <u>E</u> □ Folio Rev. <u>IS</u> □ 2- Engrave Part # and Batch # , and affix labels □ (D3136-3)	0.00 0.00							<u>OK 09/11/04</u>
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							<u>OK 09/11/04</u>
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							

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Item ID: D3136-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Window Assembly

Start Date: 11/04/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

180



Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

Scrap

~

Work Order ID 53430

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Page 4

Item ID: D3136-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Window Assembly

Start Date: 11/04/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

mf
09-11-05

Picklist Print

November 4, 2009 10:05:11 AM

Page 1

Work Order ID: 53430

Parent Item: D3136-043RevE

Parent Item Name: Window Assembly



Start Date: 11/04/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3108-9RevB1		Manufactured	No			100	Each	804.0000	2.0000			
												
Decal												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 804

34554 316

46546 488

MACRLICS.125

Purchased

No

170

sf

198.8491

3.9000



1/8" Polycast II Sheet



B 911-4

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT 198.8491

110115 4

110633 17.2295

111711 67.7447

112888 109.8749

112888

DART AEROSPACE LTD		Work Order:	53430
Description: WINDOW ASSEMBLY		Part Number:	D3136-043
Inspection Dwg: D3136-3 Rev: E		Page 1 of 1	

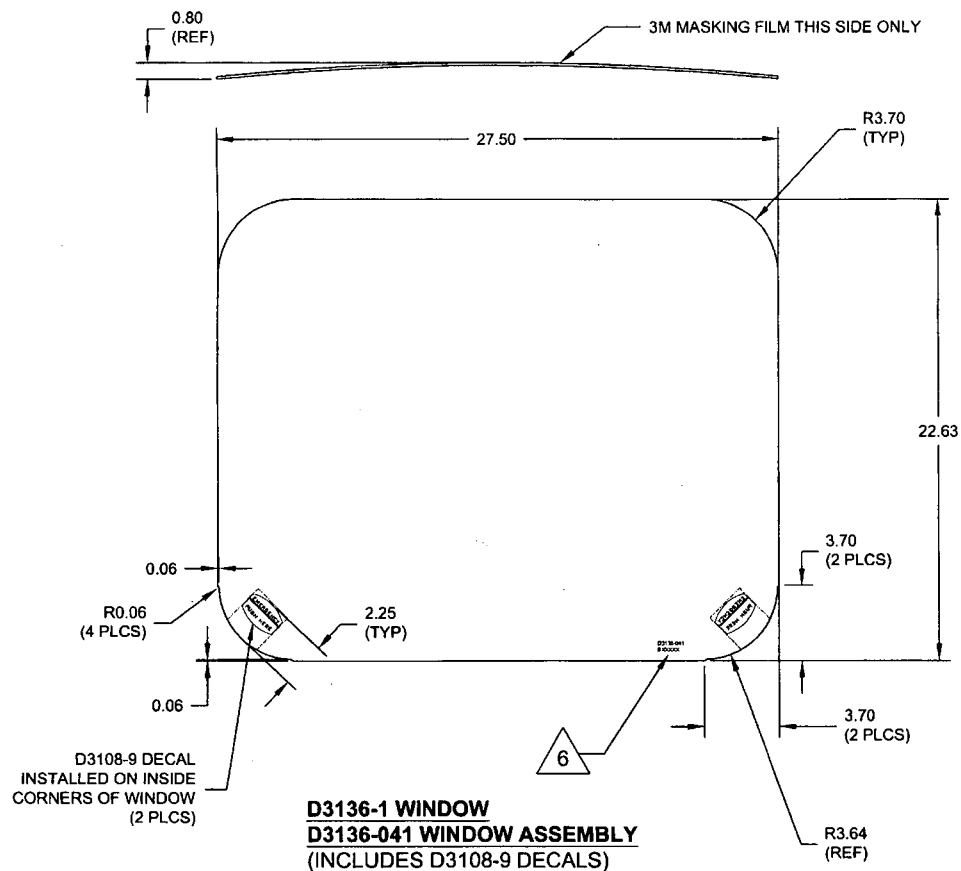
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
25.75	± .030	25.75	✓			
21.00	± .030	21.00	✓			
4.00	± .030	3.995	✓			
.06	± .020	.071	✓			
26.25	± .030	26.25	✓			
.125	± .010	.121	✓			
25.75	± .030	25.625	Ph	✓		
21.00	± .030	20.825	Ph	✓		
26.25	± .030	26.125	Ph	✓		

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-11-4	Date: 02/16/4	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

RELEASED
 07.09.22

E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3136	REV. E SHEET 1 OF 2
TITLE WINDOW ASSEMBLY	SCALE 1:6

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